

Date: Wednesday, 07/05/2008 11:55:47 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP
 Job Number : 39098
 Estimate Number : 11119
 P.O. Number :
 This Issue : 07/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D30411
 First Issue : // Type : MACHINED PARTS Drawing Number : D3041 REV.C
 Previous Run : 35978 Project Number : N/A
 Material :
 Due Date : 23/05/2008 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : JUL 08.5.07
 Comment : Est:A 01.07.11 New Issue SM
 est B 07.04.09 rev.c dwg EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0875 f(s)/Unit Total : 3.4986 f(s)

Lug Extrusion

(D2423)

Batch: B33310

C208/05/08 (40)

2.0 BAND SAW BAND SAW



cut @ meter

Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



PG

issue P/O 6324

C208/05/09 40

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

machine pending
D 3041 REV.C

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Receive + inspect for transit damage
ensure cap attached

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC2 SECOND CHECK



Comment: SECOND CHECK inspect level 5.

C208/05/08 (40)
C208/05/08 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 39098

Part Number: D30411

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(40)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

RH/SL 08-05-20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/20 (40)

8.0

POWDER COATING

POWDER COATING



M107925



(40X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

START TIME:

11:20

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:50

m.d 08/05/21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(40)

Comment: INSPECT POWDER COAT

FF 08/05/21

10.0

D2611

Bearing



(40)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description

1 D2611 Bearing

Batch

13V
31888

39124

(27X)

5/5/21

SLP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

FF 08-05-22

(40)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/22 (40) counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 07/05/2008 11:55:47 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 39098

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57465

8/5/23 *(40)*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-23

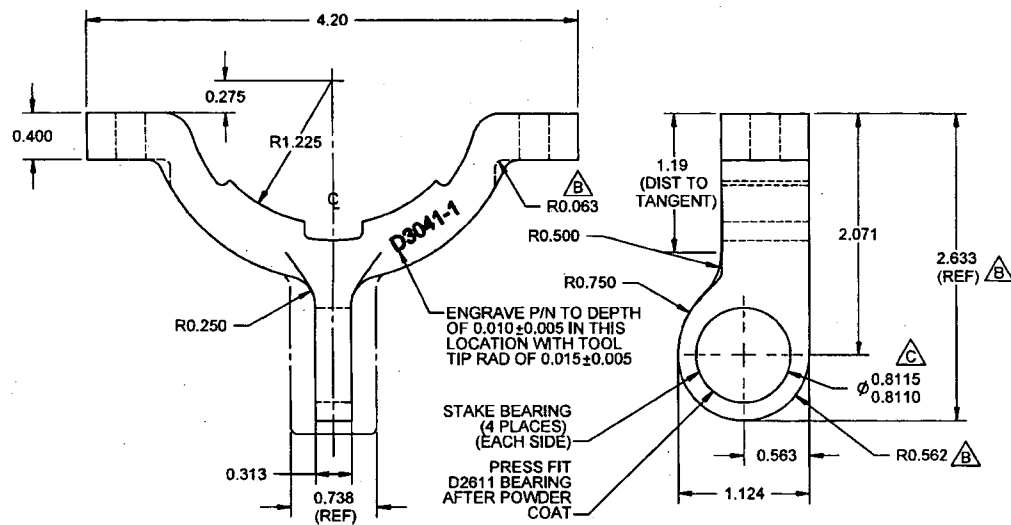
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

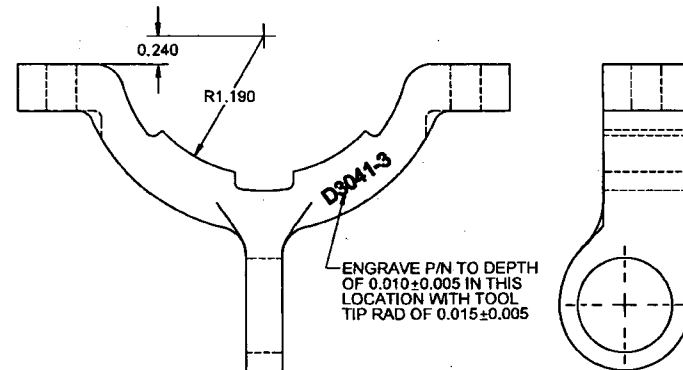
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

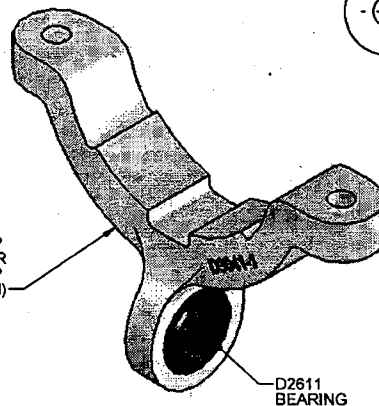
NOTE: Date & initial all entries



D3041-1 CLAMP



D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)



NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT C

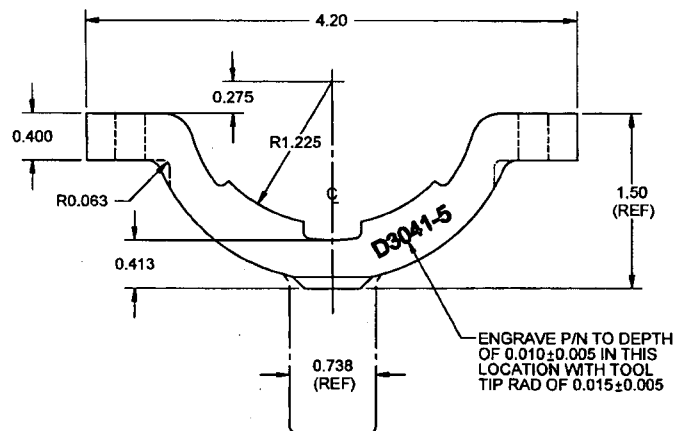
NO
31078
WORK ORDER
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SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5A-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	TITLE	REV. C
06.10.18	CLAMP	SHEET 1 OF 2
		SCALE 1:1

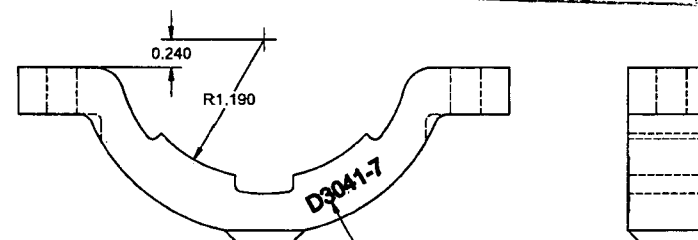
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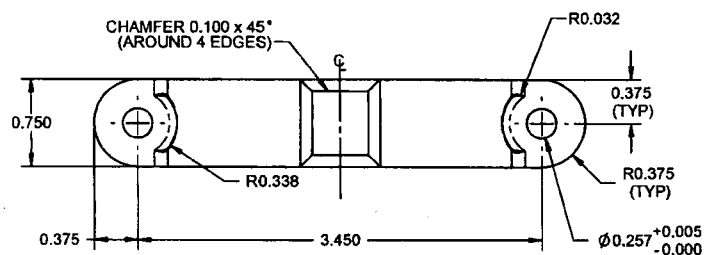
06.11.17



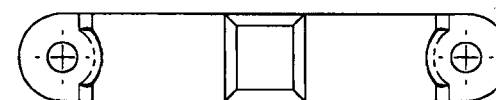
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



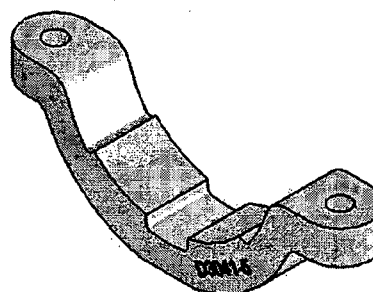
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3041-5 CLAMP



D3041-7 CLAMP
(SAME AS D3041-5 EXCEPT AS SHOWN)



NOTES:

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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT C

NO. 34098
WORK ORDER
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SUBJECT TO AMENDMENT
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ENGINEERING
RETURN TO
SHOP COPY

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	06.10.18	D3041	SHEET 2 OF 2
		CLAMP	SCALE
			1:1

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

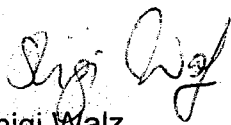
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3041-1	Lug B39098	6324

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 16, 2008